

107

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File Edit View Insert Format Records Tools Window Help									
Date	Shift	Equipment	System	Product Code	Lot Number	Submitted by:	Supervisor's Name	Group Leader's N	
01/03/2000	1	Line 1		1006	123456	Jose Inzary	Carmen Ramos	Brandy Chocolate	
01/03/2000	2	Line 1		1001	123456	Migdalia Rodrig	Short Fuse	Sammy Jimenez	
01/03/2000	3	Line 1		1001	123456	SI	Smart Dog	Denisse Brown	
01/04/2000	1	Line 1		1002	654321	JI	Carmen Ramos	Brandy Chocolate	
01/04/2000	2	Line 1		1002	654321	MR	Short Fuse	Sammy Jimenez	
01/04/2000	3	Line 1		1002	654321	SI	Smart Dog	Denisse Brown	
01/14/2000	1	Line 1		1001	90P0014	Carmen Gonzale	Short Fuse	Carmen Gonzalez	
01/15/2000	1	Line 1		1001	90P201	Rafael Lebron	Carmen Ramos	Jose Barreiro	
01/17/2000	1	Line 1		1001	90P0714	Evelyn Santiago	Evelyn Santiago	Jorge Medina	
01/18/2000	1	Line 1		1004	124365	JI	Carmen Ramos	Brandy Chocolate	
01/18/2000	2	Line 1		1004	124365	MR	Short Fuse	Sammy Jimenez	
01/18/2000	3	Line 1		1004	124365	SI	Smart Dog	Denisse Brown	
01/21/2000	1	Line 1		1001	90p0099Z	E Martinez	Eillen Bergquist	Ismael Olmedo	
01/22/2000	2	Line 1		1003	111111	JI	Carmen Ramos	Black Chip	
01/24/2000	1	Line 1		1001	90P0045	Jorge Burgos	Lucy Carrion	Jorge Burgos	
01/25/2000	1	Line 1		1001	90B004	Marisel Penistor	José Mejías	Graciela Claudio	
01/26/2000	1	Line 1		1001	90P0035E	Marissa Betanc	Manssa Betancourt	Ana Ocasio	
01/31/2000	1	Line 1		1001	567890	JI	Carmen Ramos	Brandy Chocolate	
01/31/2000	2	Line 1		1001	567890	MR	Short Fuse	Sammy Jimenez	
01/31/2000	3	Line 1		1001	567890	SI	Smart Dog	Denisse Brown	
*									

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24

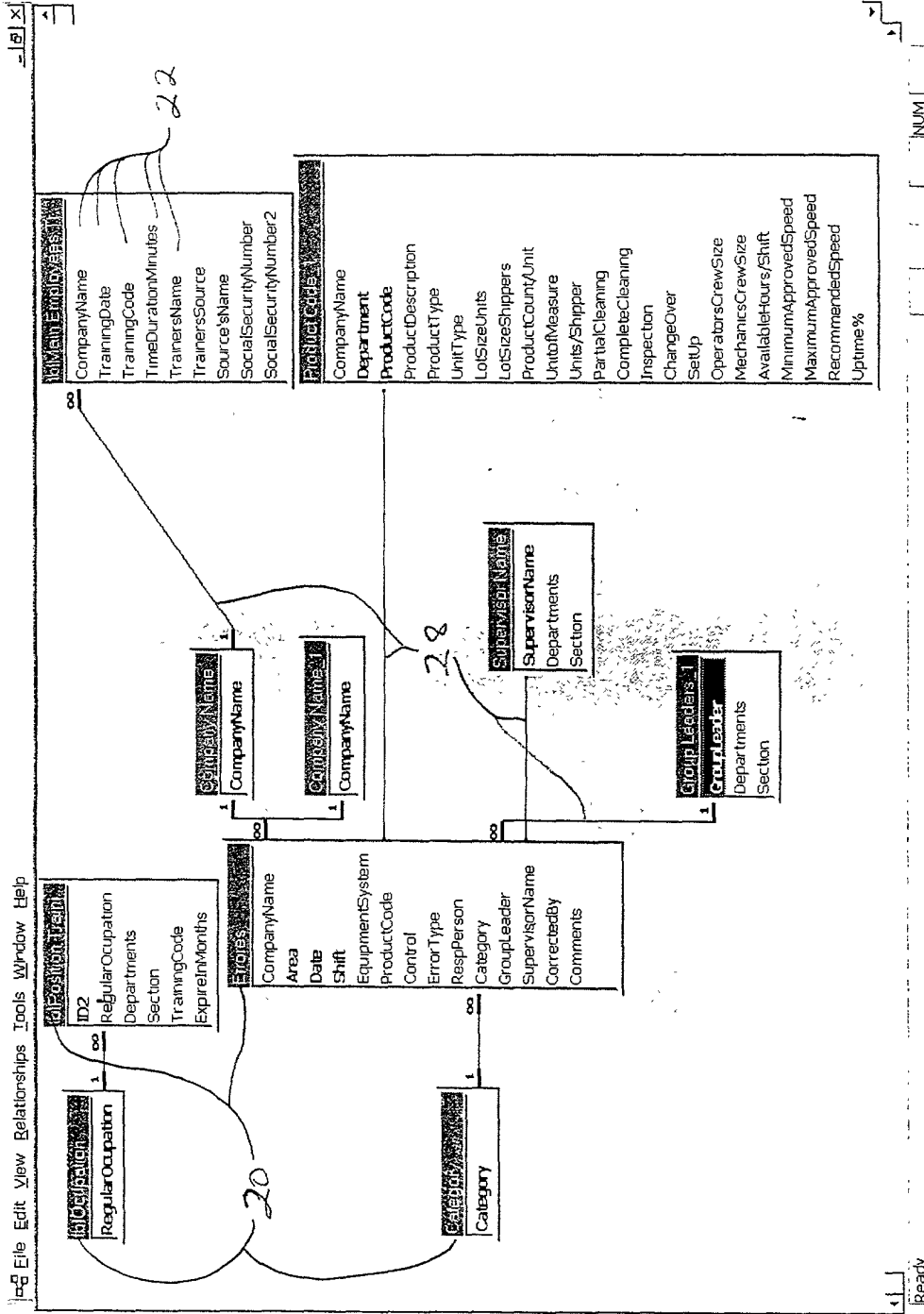


Fig. 2

Date: (mm/dd/yyyy)
01/03/2000

Shift
1

Equipment System
Line 1

Product Code
1006

Lot Number
123456

Submitted by:
Jose Lizary

Supervisor's Name:
Carmen Ramos

Group Leader's Name:
Brandy Chocolate

Mechanic's Name:
Ugly Guy

QC Inspector's Name:
Old Man

Operators
7

*Partial Cleaning
30

*Complete Cleaning
60

*Inspection
10

*Change Over
120

*Set Up
10

Units Shipped (U/Min)
200

Operators
7

*Partial Cleaning
0

*Complete Cleaning
90

*Inspection
16

*Change Over
120

*Set Up
15

*Breaks
45

Shift Hour:
1st
2nd
3rd
4th
5th
6th
7th
8th

Totals

Shippers:
20
4,000

20
20,000

25
5,000

23
4,600

14
2,800

18
3,600

32
6,400

30
6,000

262
52,400

Product Run Alert
Alert Category
Broken Tablets

Alert Details
Tablets are found broken Source of origin for breakage is unknown

Product Run Alert
Alert Category
Broken Tablets

Alert Details
Tablets are found broken Source of origin for breakage is unknown

Product Run Alert
Alert Category
Broken Tablets

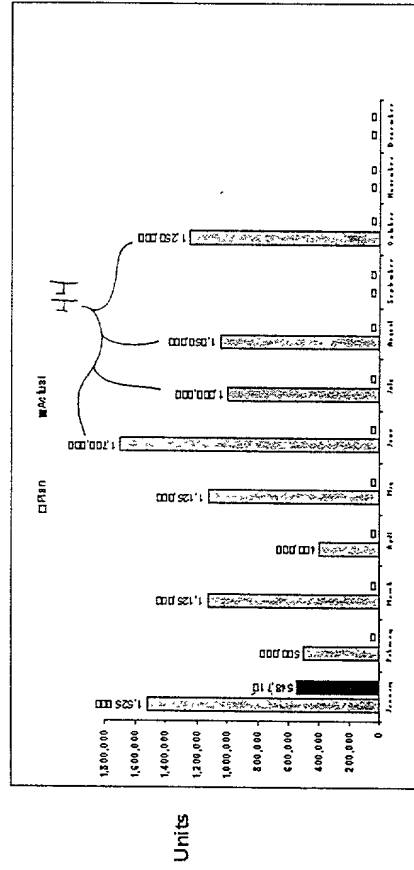
Alert Details
Tablets are found broken Source of origin for breakage is unknown

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Actual vs Plan by Equipment System
For Line 1

Wonder Pharmaceuticals Inc.

Year: 2000



Plan Total: 9,675,000 Actual Volume Variance (Units) For The Year: -9,126,290
Actual Total: 548,710 Actual Volume (Percent of Plan): 5.67%

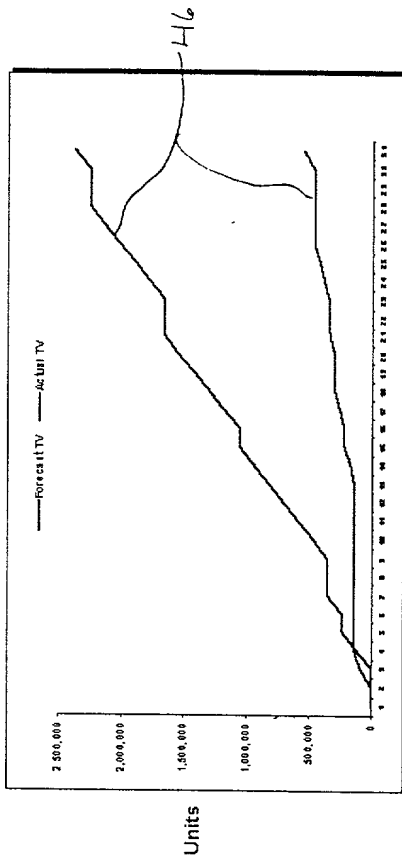
Director by Business Systems

Wednesday, July 19 2000

Fig. 4

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Actual vs Forecast Cumulative Volume
Wonder Pharmaceuticals Inc.
Date Period: from 01/01/2000 to 01/31/2000
All Shift:



Actual Volume Variance (Units) For The Period: -1,821,290

Director by Business Sense Inc

Wednesday, July 19, 2000

40-3

Actual vs Plan by Equipment System For Line 1

Wonder Pharmaceuticals Inc.

Year: 2000

Plan Total: 9,675,000 Actual Volume Variance (Units) For The Year: -9,126,290
Actual Total: 548,710 Actual Volume (Percent of Plan): 5.67%

Month	Plan Volume	Actual Volume	Variance	Percent
January	1,525,000	548,710	9,126,290	35.98%
February	500,000	0	9,126,290	0.00%
March	1,125,000	0	-9,126,290	0.00%
April	400,000	0	-9,126,290	0.00%
May	1,125,000	0	-9,126,290	0.00%
June	1,700,000	0	-9,126,290	0.00%
July	1,000,000	0	-9,126,290	0.00%
August	1,050,000	0	-9,126,290	0.00%
September	0	0	-9,126,290	0.00%
October	1,250,000	0	-9,126,290	0.00%
November	0	0	9,126,290	0.00%
December	0	0	-9,126,290	0.00%

Director by Business Inc. Wednesday, July 19, 2000 Page 1 of 1

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Fig. 6

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Product Run Alert Report


Date Period: from 01/01/2000 to 01/31/2090

W-011

E System	P Code	Product/Description	Lot #	Date	Shift	Supervisor	Crew/Leader	Mechanics	QC In speaker	Supervisors	Units	Alert
Line 1	1001	Worder Cough Medicine	124365	01/15/2010	2	Smallsing	Bertine Brown	John Figueroa	Carlos Diaz	112	2,500	Broken
Line 1	1001	Worder Cough Medicine	124365	01/15/2010	2	Smallsing	Sammy Jimenez	Carlos Diaz	Mike Wicks	250	21,000	Broken
Line 1	1001	Worder Cough Medicine	124365	01/15/2010	1	Carmen Ramos	Benny Chocolate	light Olay	Old Man	170	13,000	Broken
Line 1	1001	Worder Headache Medicine	507021	01/14/2010	1	Smallsing	Carmen Gonzalez	Carlos Burgos	Old Man	205	25,500	Broken
Line 1	1001	Worder Headache Medicine	507021	01/05/2010	1	Martina Betancourt	Ava Gomez	Heriberto Arroyo	Old Man	465	46,500	Broken
Line 1	1001	Worder Headache Medicine	507021	01/15/2010		Carmen Ramos	Jose Barrios	John Figueroa	Carlos Diaz	515	51,500	Broken

Director by Bureau Sense Inc

Wednesday, July 19 2000



DSS TM
cto

Productivity Recovery And Improvement
Software For Manufacturing Areas

30

50

38

52

Official Annual Forecast

Capacity Analysis

Production Monthly Plan

Forecast Days Of The Month

Daily Production Module

Downtime Module

Production Waste Module

Documentation Errors Module

Personnel Training Module

Tables Update


Exit Database

Fig 8

TT99350 TT99350

File Edit View Insert Format Records Tools Window Help

Go Favorites

Production Waste Module		Business Sense Inc.	
Date: (mm/dd/yyyy)	Shift	Equipment System	Lot Number
01/01/2000	2	Line 1	123456
Waste Source	Component Code	Quantity	Unit of Measure
Change Over & Setup	123456	100.0000	Each
<div> <div>  30~ 525 </div> <div> 34 </div> <div> 38 </div> <div> Reports Menu </div> </div>			
Record: 11 of 1			


Form View

Fig. 9

Personnel Training Module Facility Name: <u>Wonder Pharmaceuticals Inc</u>		Training Code: <u>G3210</u>		Training Date: <u>10/15/2000</u>	
Time Duration (Minutes): <u>60</u>		Trainer's Name: <u>Jose Ibarra</u>		Trainer's Source: <u>Outside Consultant</u>	
Source's Name: <u>Business Sense Inc.</u>		Employee: <u>Employee</u>		Social Security Number: <u>456-54-6546</u>	
Non Employee Social Security Number: <u> </u>		Non-Employee: <u> </u>			

Personnel Training Module

38



30 ~

30

New Trainee

Reports Menu

Required Tables

38

(1999 Copyright Business Sense Inc.)

FIG. 10



Documentation Errors Module

Business Sense Inc.

Company Name	Wonder Pharmaceuticals Inc	Date	1/1/00	Area	Packaging	Shift	1	Equipment System	Line 1
Product Code	1001	Lot Number	12345	Error Type	Blank Spaces	Error Creator			
Employment Category	Regular	Group Leader	Brandy Chocolate	Supervisor's Name	Smart Dog	Corrected By			
Comments									

Documentation Errors Module

20 ~

S2

34

38

Repeat Header

Reports Menu

20

38

Record: 14 of 11

FIG. 11

Official Annual Forecast

Business Sense Inc.

Official Annual Forecast — 52

Time Period

Date

11/20/1999

Production Area

Packaging

Period From

01/01/2000

Period To

12/31/2000

Annual Volume Lots

34

Equipment System

Line 1

Product Code

1001

Month

September

Lots

0

30

38

Add Lots

New Product

Record: 14 of 72

TOPSON 2799660

[-] [E] [X]

Ditector

File Edit View Insert Format Records Tools Window Help

Production Capacity Analysis Form				Business Sense Inc.	
Production Capacity Analysis Form					
<u>Heading Data</u>					
Date	Forecast Heading	Period From	Period To		
11/20/2000	Wonder Pharmaceuticals Inc. For	01/01/2000	12/31/2000		
Calendar Days	Holidays	Shut Down Days			
366	12	21			
<u>Product Data:</u>					
Product Code	Total Lots	Total Groups	Group Size	Equipment System	
1001	140	3	5	Line 1	
30		38		Report	
Record: 14 of 9					

FIG. 13

Date: [mm/dd/yyyy]

1/23/00

Shift

1

Equipment System

Line 1

Lot Number

123456

Equipment Code

Lab 1

Downtime Code

Lab 1 2

Downtime Description

Label rolls break frequently

Action Taken

Label roll tension was adjusted to prevent breakage

Action Taken Category

Adjustments

Area Responsible For Downtime

Maintenance

Best Solution Criteria

Standardize Adjustments

Equipment System/Downtime

Start Time

7:30

End Time

9:32

Equipment System/Downtime

Start Time

Equipment Downtime

End Time

Equipment System/Downtime

Start Time

Equipment System Downtime (Minutes)

122

Equipment System/Downtime

Start Time

Equipment Downtime (Minutes)

30

52 ~ Downtime

30 Module

Repeat Header

Reports Menu

Record: 14 of 28

FIG. 14

Production Monthly Plan			
Date 12/28/1999	Equipment System Line 1	Period From 01/01/2000	Period To 01/31/2000
	Year 2000	Product Code 1001	Total Lots 6
Update Plan		Add More Lots	1+

(Handwritten annotations: "34" near Date and Year fields; "32" near Product Code field; "30~" at bottom left; a star symbol at bottom right)

10:50:20 2/19/99

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100

Dissector

File Edit View Insert Format Records Tools Window Help

Forecast Days of The Month

Business Sense Inc.

52 Forecast Days of The Month

Equipment System

Line 1

Period From

01 Jan-2000

Period To

31 Jan-2000

Total Lots

21

Total Units

2,370,000

Shift 1

Shift 2

Shift 3

1

2

3

4

5

6

7

8

9

10

11

12

13

14

15

16

DAY OF THE MONTH

17

18

19

20

21

22

23

24

25

26

27

28

29

30

31

Shift 1

Shift 2

Shift 3

DAY OF THE MONTH

17

18

19

20

21

22

23

24

25

26

27

28

29

30

31

Shift 1

Shift 2

Shift 3

DAY OF THE MONTH

17

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22

23

24

25

26

27

28

29

30

31

Record: 14

1

2

3

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99

100

Update Plan

38

Fig. 16

Product Code Table		Business Sense Inc.	
Product Code Table <u>52</u>		Company Name: <u>Business Sense Inc</u>	
Product Description:			
Production Area: <u>Packaging</u>	Product Code: <u>1</u>	Product Description: <u>Product 1</u>	Product Type: <u>Tablets</u>
Unit Type: <u>Bottle</u>	Lot Size (Units): <u>8,016</u>	Lot Size (Shippers): <u>167</u>	Unit Of Measure: <u>Each</u>
		Unit Count: <u>100</u>	Units / Shipper: <u>48</u>
Standards: * (Time in Minutes)			
Partial Cleaning Time: <u>45</u>	Complete Cleaning Time: <u>75</u>	Inspection Time: <u>15</u>	Change Over Time: <u>60</u>
			Set Up Time: <u>60</u>
Operators Crew Size: <u>7</u>	Mechanics Crew Size: <u>1</u>	Available Hours / Shift: <u>7.0</u>	Uptime %: <u>60.0</u>
Validation Values:			
Minimum Approved Speed (U/Min): <u>60</u>	Maximum Approved Speed (U/Min): <u>100</u>	Recommended Speed (U/Min): <u>90</u>	
Product Codes Report: <u>302</u>			
Record: <u>14</u> of <u>119</u>			

FIG. 17